

Work Order ID 149899

August 09, 2016 8:43:59 AM

149899

Page 1

Item ID: D119-646-241
 Revision ID: ~~URF-15-560~~ *16.08.08*
 Item Name: Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH
 Start Date: 8/8/2016 Start Qty: 1.00
 Required Date: 8/8/2016 Req'd Qty: 1.00
 Reference: *REWORK*

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: *SHA* Date: *AUG 08 2016*
 QC: _____ Date: _____ Tooling: _____ Date: _____
 SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3887-045	D								
IIN-D119-646	C								

101

0.00

101

QC

Quality Control

Memo

0.00

PULL FROM STOCK D119-646-241 B118478 X1

CHG003

MASK AREA ACCORDING TO THE ATTACHED DIAGRAM

REMOVE PAINT IN THAT AREA

TOUCH UP ALODINE IF NEEDED

CLEAN AREA

SN/A

CHECK IF HOLES WERE PLUGGED WITH AN3C4A BOLTS

DART			
1270 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7 TEL: 513-632-5200 www.dartaerospace.com			
PATENT	US #5735484 / CA #2222184 / EURO #0828655		
P/N	D119-646-241	CHG	CHG003
DESC	Replacement Skidtube STD	SIC	SR02024SE
LOT	B118478	SIC	
MODEL	Agusta A119/AW119MKII	SIC	
TC APPROVAL: 09-89		MADE IN CANADA	
		02729-4	

122

QC5- Inspect part completeness to step on W/O

0.00

122

QC

Quality Control

Memo

0.00

DAS
16
9-89

16/08/09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
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Work Order ID 149899

149899

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August 09, 2016 8:44:00 AM

Item ID: D119-646-241 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: URF 15-560 Stop ***NS2***
Item Name: Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH
Start Date: 8/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 8/8/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Identify as per dwg & Stock Location: <u>W/C</u>	0.00							
260									
Packaging	Memo	0.00				<u>1X</u>			<u>16/08/10</u>
Packaging	ADD NEW LABELS AND PAPERWORK								
	Location : FG084								
270	QC21- Final Inspection - Work Order Release	0.00							
270									
QC	Memo	0.02							<u>16/8/10</u>
Quality Control									

SH

AUG 09 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

August 09, 2016 8:44:06 AM

Page 1

Work Order ID: 149899

149899

Parent Item: D119-646-241

D119-646-241

Parent Item Name: Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

Start Date: 8/8/2016

Required Date: 8/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC IPP REV B
12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20
per chg003 ECN13-534 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D119-646-241		Manufactured	No				Each	2.0000		1			
--------------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

D119-646-241

Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

** B118478 ① 16/8/8 ^{DAS} 28 ~~28~~

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG084	2	
118472	1	
118477	1	

DQA:

Date:

QA Closed:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only


Work Order: ~~141824~~ 149899

Part No. D119-646-041

NCR No.

DISPOSITION

 Rework ☒
 Scrap ☐
 Use-as-is ☐
 Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

 Skid-tube ☐
 Machining ☐
 Thermoforming ☐
 Large Fab ☐

 Cross tube ☐
 Small Fab ☐
 Finishing ☐
 Composite ☐

 Water Jet ☐
 Prod. Eng. Coord. ☐
 Rec/Store/Packaging ☐
 Supplier ☐

 Engineering ☒
 Quality ☐
 Other ☐

Date: 16/5/16

Step #: 200

QTY Effective :

Description Work Order Deviation

Disposition

No powder coat on saddle region per customer request.

Acceptable per attached Masking instructions

MRB (QS1042) Approval

 DAS
 12 16/6/17
 9-89

Completed By

 16/08/15
 DAS
 15
 9-89

Lead hand / Supervisor Approval Verification

DAS

9

9-89

16-08-03

QA Coordinator Approval

9

9-89

16-08-03

Root Cause

Environment	☐	No Re-verification	☐
Design	☒	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

 Pressure/Forced ☐
 Bending ☐
 Centre Not Concentric ☐
 Cracks ☐
 Crimp/Kink/Ripple/Wave ☐
 Cuffs ☐
 Crushing ☐
 Heat Treat ☐
 Wave/Twist in Tube ☐
 Marks/Chatter ☐

FAULT CATEGORY

 Temperature/Cure ☐
 Set-up ☐
 BOM/Route ☐
 Broken/Damage/Defect ☐
 Inspection Incomplete/Unqualified ☐
 Contamination ☐
 Countersink ☐
 Cut Too Short ☐
 Instructions Incomplete/Unclear ☐
 Drill Holes ☐

 Power Loss/Surge ☐
 Folio/Program ☐
 Grain ☐
 Weld ☐
 Wrong Stock Pulled ☐
 Out of Sequence ☐
 Off-set ☐
 Misabeled ☐
 Fit/Function ☐
 Misaligned/off center ☐

 Positioned Wrong ☐
 Outside Dimensions ☐
 Over/Under tolerance ☐
 Part Incorrect ☐
 Part Lost/Missing ☐
 Part Moved ☐
 Drawing ☐
 Finish ☒
 Misread ☐
 Turning Sequence ☐
☒ OTHER: Customer

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Copy

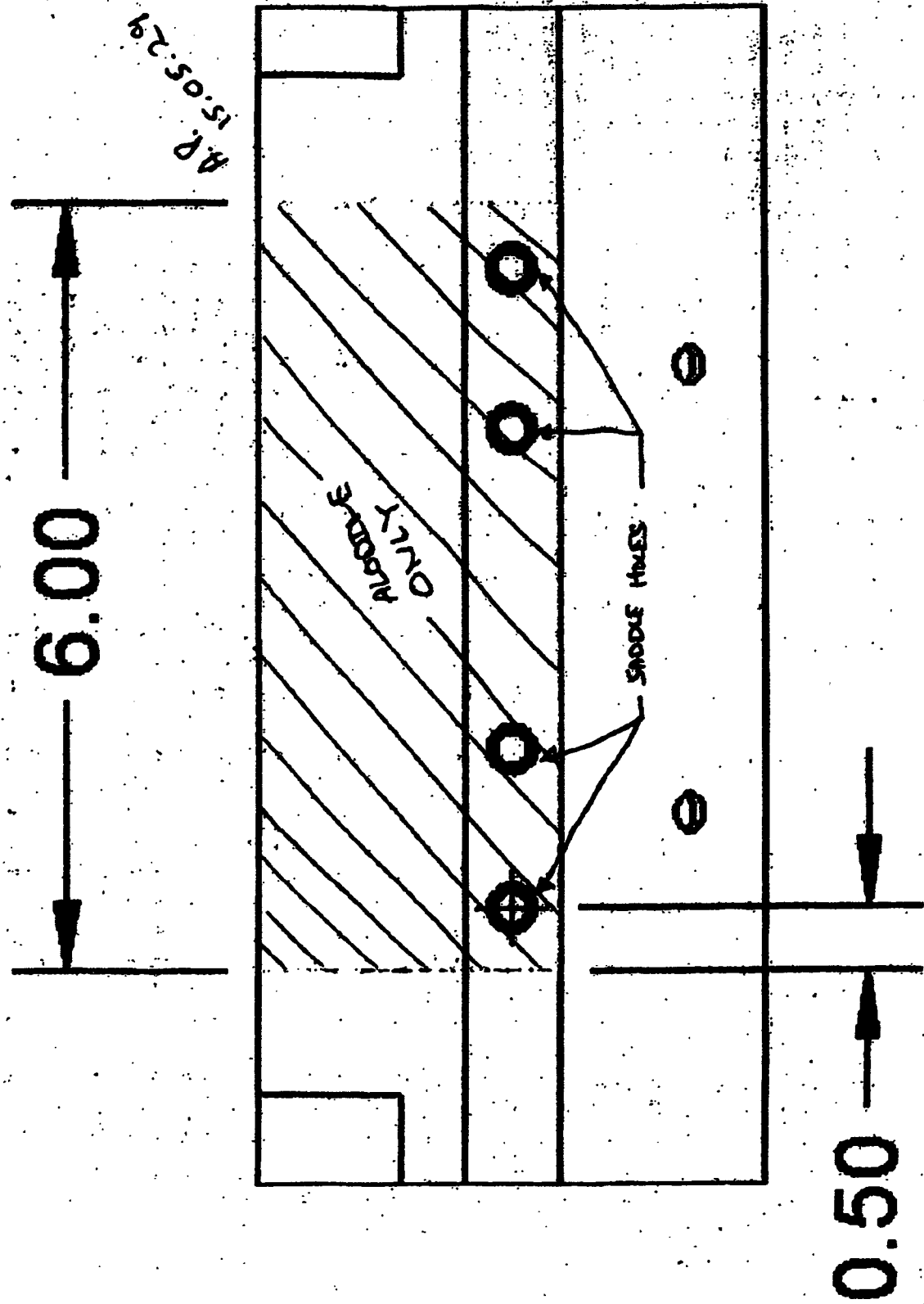


QA Closed: _____ Date: _____

Work Order update only ☒

149899 <i>W/A 829</i> Work Order: _____ Part No. <i>2119-646-041</i> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																																	
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Description Work Order Deviation <i>Plug unused holes with AN3C4A Bolts rather than AN3CSA Bolts.</i>				Disposition <i>Acceptable</i> <i>AU3C-4A / M135297 (x6)</i> <i>M/A S</i>																																																																																																																																			
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Copy



Work Order ID 118478

Friday, October 24, 2014 1:18:59 PM

118478 BH

Page 1

Item ID: D119-646-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

Start Date: 10/20/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/31/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference: ra111753-2

Approvals: Process Plan: MF Date: 14-10-24 Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3887-045	C
IIN-D119-646	B

280

0.00

ML5
15-03-25***280***

HandFinish

Hand Finishing

Memo

0.00

PULL FROM STOCK D119-646-241 X 1 B101903

Remove FWD & AFT caps D2855-3.

Clean all sikaflex off cap & identify per each tube caps was removed (P/N & B#)

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ONT CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-6200	
P/N	D119-646-212	CHG	CHG004		
DESC.	Skidtube STD, RH	STC	SR02024SE		
LOT	B98787	STC			
MODEL	Agusta A119/AW119MKII	STC			
DART INC. 25 7575-60 CA 722210 EUROPEAN NO. 7-082855				MADE IN CANADA 02/2014	

-241 (106903)

290

0.00

290

Skidtubes

Skidtubes

Memo

0.00

Drill out & remove FWD Cross bolt spacers D2579 in Detail C on Dwg D3887SKI

Reposition location of holes as per Drawing but using +/-0.005" tol and per symmetrical in QSI 018

TACK ONLY CroHss bolt spacers D2579 B 123997 x1

1 Ø B64-10-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 118478
Friday, October 24, 2014 1:18:59 PM

118478

Page 2

Item ID: D119-646-241

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

Start Date: 10/20/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 10/31/2014 Req'd Qty: 1.00 *1*

Customer:

Reference: ra111753-2

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC5- Inspect part completeness to step on W/O	0.00							
300									
QC	Memo	0.00							
Quality Control	Location MUST be verified by QC Record Dims HERE								
310		0.00							
310									
QC	Memo	0.00							
Quality Control									
320		0.00							
320									
Skidtubes	Memo	0.00							
Skidtubes	Weld as per QSI 004 A/R <u>m129285</u> Back Drill Grind welds flush & deburr								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 118478

Friday, October 24, 2014 1:18:59 PM

118478

Page 3

Item ID: D119-646-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

Start Date: 10/20/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/31/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference: ra111753-2

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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330 QC5- Inspect part completeness to step on W/O 0.00

330

QC

Memo

0.00

Quality Control

① 14-10-27 PD

340 QC10- Inspect visual per QSI004- ground welds 0.00

340

QC

Memo

0.00

Quality Control

① 14-10-27 PD

350 0.00

350

Purchasing

Memo

0.00

Purchasing

Send tube to be striped as per QSI004
PO# 26625OK 14/11/26 ①

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 118478

Friday, October 24, 2014 1:18:59 PM

118478

Page 4

Item ID: D119-646-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

Start Date: 10/20/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/31/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference: ra111753-2

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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360 Receive & Inspect for Damage & Mat'l Certs 0.00

360

Packaging

Memo

0.00

Packaging

IX SPI4-12-8

370 QC6- Inspect dimensions to drawing 0.00

370

QC

Memo

0.00

Quality Control

① 14.12.15 DAS 9 8-89

380 Chemical Conversion Coat per QSI005 4.1 0.00

380

HandFinish

Memo

0.00

Hand Finishing

15-2-13 11/10/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 118478

Friday, October 24, 2014 1:18:59 PM

118478

Page 5

Item ID: D119-646-241

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

Start Date: 10/20/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/31/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference: ra111753-2

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
390	QC7-Inspect Chemical Conversion Coat	0.00							
390									
QC	Memo	0.00							
Quality Control									
400	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
400									
Powdercoat	M 129808 Memo	0.00							
Powder Coating									
410	QC3- Inspect Part Finish	0.00							
410									
QC	Memo	0.00							
Quality Control									

① 15-3-3 DAS 34 9-89

START: 1:10
OVEN T: 320°
FINISH: 1:40

1 15-3-3 15/34 9-89

11/3/11 15/103/06 DAS 15 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Friday, October 24, 2014 1:18:59 PM

Item ID: D119-646-241

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

Start Date: 10/20/2014 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 10/31/2014 **Req'd Qty:** 1.00 ***1***

Customer:

Reference: ra111753-2

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Work Order ID 118478***118478***

Page 7

Friday, October 24, 2014 1:19:00 PM

Item ID: D119-646-241

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

Start Date: 10/20/2014 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 10/31/2014 Req'd Qty: 1.00 ***1***

Customer:

Reference: ra111753-2

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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440	QC21- Final Inspection - Work Order Release	0.00							
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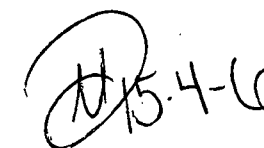
440

QC

Memo

0.00

Quality Control

ML5 1504-07

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
--	--	---	---

Picklist Print

Friday, October 24, 2014 1:18:59 PM

Page 1

Work Order ID: 118478

118478

Parent Item: D119-646-241

D119-646-241

Parent Item Name: Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

Start Date: 10/20/2014

Required Date: 10/31/2014

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP REVB

12.11.05 (DEOD3887-B-1)(ecn 12-675) DD verf:JLM IPP REV:C 13.03.20

per chg003 ECN13-534 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D119-646-241

Manufactured No

Each

0.0000

1

D119-646-241

Replacement Skidtube with Run-on Landing Wearplates, Fits LH or RH

1 x 101903
mf
14-10-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

AN3CSA BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

SEAL WITH
SIKAFLEX-241/291

D2855-3 CAP

AN3C46A BOLT
D3904-1 WASHER, 2 PL
MS21043-3 NUT
8 PL

D3849-043
AFT TRAINING WEARPLATE ASSY

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

1.5 1.5 1.5

2.00 DISTANCE TO D3885-1 WEB

1.5 D2855-3 CAP

SEAL WITH
SIKAFLEX-241/291

MS24694-C52 SCREW
(1 PER SIDE)

D3849-041
FWD TRAINING WEARPLATE ASSY

D3887-045 STANDARD SKIDTUBE ASSY WITH TRAINING WEARPLATE
(MAKE FROM D3387-13)

#118478
RELEASED
2013-03-19
wp

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	D	D3887	SHEET 4 OF 8
APPROVED	19	TITLE	SCALE
DE APPR.	19	A119 STD SKIDTUBE ASSY	NTS
DATE	13.02.19	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED TO THE PUBLIC EXCEPT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

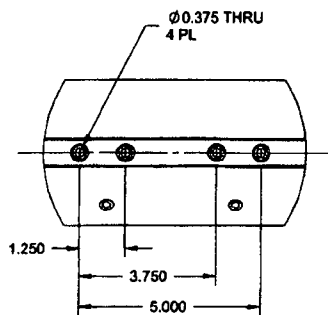
Work Order update only ☐

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Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

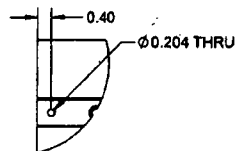
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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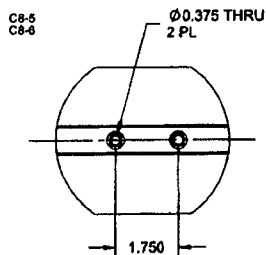


DETAIL A
SCALE 4X

D7-5
C3-5
D7-6
C3-6

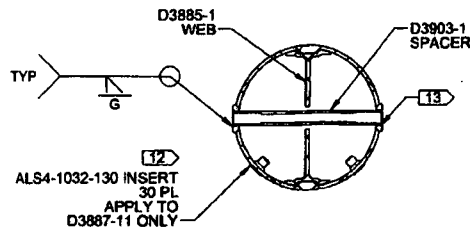


DETAIL F
SCALE 4X



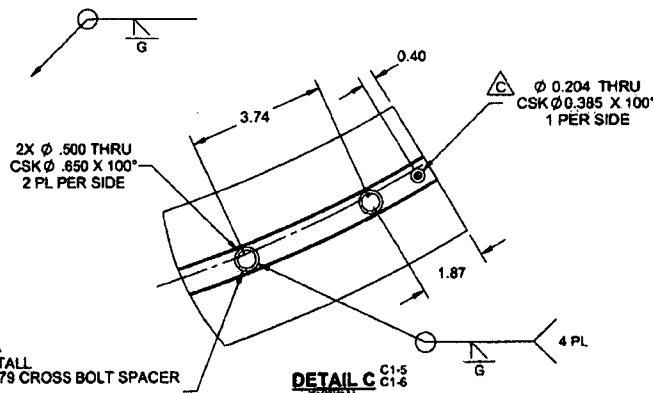
DETAIL B
SCALE 4X

C4-5
C5-5
C4-6
C5-6



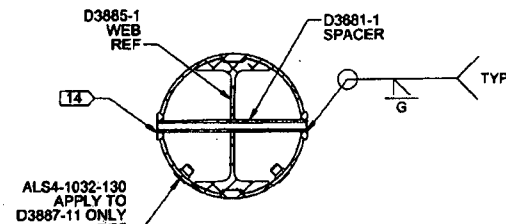
SECTION D-D
SCALE 4X
(FOR 12 X Ø 0.375 HOLES
PER SKIDTUBE)

C7-5
C3-5
C7-6
C2-6



DETAIL C
SCALE 4X

C1-5
C1-6



SECTION E-E
SCALE 4X
(FOR 8 X Ø 0.313 HOLES
PER SKIDTUBE)

C4-5
C4-6

- NOTES:**
- 13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø 0.375 HOLES ONLY:
- i) CHAMFER HOLES Ø 0.475 x 45°
 - ii) INSERT D3903-1 SPACER
 - iii) WELD INTO PLACE AND GRIND FLUSH
 - iv) C'BORE TO 0.313 x 0.75 DEEP
 - v) DEBURR HOLES
- 14) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø 0.313 HOLES ONLY:
- vi) CHAMFER HOLES Ø 0.354 x 45° OR 0.050 DEEP x 45° (BOTH SIDES)
 - vii) INSERT D3881-1 SPACER
 - viii) WELD INTO PLACE AND GRIND FLUSH
 - ix) DEBURR HOLES

RELEASED
2013-03-13

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DB	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	NS	D3887	SHEET 7 OF 8
APPROVED	NS	TITLE	SCALE
DE APPR.	NS	A119 STD SKIDTUBE ASSY	NTS
DATE	13.02.19	COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE ON THE OPEN SOURCE INFORMATION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR TRANSMISSIONS TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order:	118478
Description: Repair Scheme D119-646-241 Skid tubes FWD GHW holes do not align NCR 14-3771 For tubes in production and Returned tubes			
Drawing: D3887		Repair Scheme:	RS1015
Part No: D119-646-241		Page:	1 of 1
Batch No:		Qty:	1

Step	Location	Procedure	By	Date	Qty
1	Finishing	Remove FWD & AFT caps D2855-3. Clean all sikaflex off cap & identify per each tube caps was removed (P/N & B#)	BE	14-10-27	1
2	Skidtube	Drill out & remove FWD Cross bolt spacers D2579 in Detail C on Dwg D3887	BE	14-10-27	1
3	Skidtube	Reposition location of holes as per Drawing but using $\pm 0.005"$ tol and per symmetrical in QSI 018	BE	14-10-27	1
4	Skidtube	TACK ONLY Cross bolt spacers D2579 B 123447 x1	BE	14-10-27	1
5	QC	Location MUST be verified by QC Record Dims HERE insp with sig DT10091	PD	14-10-27	1
6	Skidtube	Weld as per QSI 004 A/R m129285 Back Drill Grind welds flush & deburr	BE	14-10-27	1
7	QC	QC 10 & 5 Inspection ***TEST FIT GHW WHEELS*** Pass ☒ with sig DT10091	PD	14-10-27	1
8	Purchasing	Send tube to be striped as per QSI004 PO# 26625	CL	14/11/26	1
9	Receiving	Receive & inspect for Damage & Material certs	IK	14-12-8	8P
10	QC	QC 6 Inspect For Damage and reverify that certs match	PD	14-10-27	
11	Finishing	Touch up alodine as per QSI 005	Dec	15-2-13	1
12	Finishing	Re-Powder coat per QSI 005	Das	15-3-3	1
13	Finishing	Re-assemble original caps back on tubes Sikaflex BM131574 exp 15/10	Das	15/03/06	x1
14	QC	QC 3 inspect	38	15-03-09	1
15	QC	QC 5 inspect	38	15-03-09	1
16	QC	QC21	MCS	15-04-07	1

Rev	Date	Change Description	Prepared	Checked	Approved
B	14.10.21	New Issue	ED		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26625

Purchase Order Date 11/26/2014
PO Print Date 11/26/2014

Page Number 2 of 3

Order From :

VC-IM1001

Ship To : DART AEROSPACE LTD

IMI MANUFACTURING INC.
772 MAIN ST. E.P.O. BOX 3
HAWKESBURY, ON K6A 2R4
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613 675 1208 Ext.223

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Line Total: \$412.1

4	118477	D119-646-241 SKIDTUBE	12/19/2014	1.00	\$412.50	\$412.1
			Yes			
			12/19/2014			
		SAME AS ABOVE				

Line Total: \$412.1

5	118478	D119-646-241 SKIDTUBE	12/19/2014	1.00 ✓	\$412.50	\$412.1
			Yes			
			12/19/2014			
		SAME AS ABOVE				

Line Total: \$412.1

6	118479	D119-646-241 SKIDTUBE	12/19/2014	1.00	\$412.50	\$412.1
			Yes			
			12/19/2014			
		SAME AS ABOVE				

Line Total: \$412.1

PO Instructions: PROCUREMENT QUALITY CLAUSES
A000 CLAUSES NOT REQUIRED

Note:

11/26/2014



2056 County Rd #4, L'Orignal, Ontario K0b 1K0

Phone 613-675-1208

Fax 613-675-1250

PACKING SLIP

TO: Dart Aerospace Ltd
1270 Aberdeen Street
Hawkesbury, On K6A 1K7

Date: December 8/2014

SALESPERSON	JOB	P.O NUMBER :	NOTE:
	14-0574-22	26625	
QTY ORDER	DESCRIPTION	QTY SHIP	LINE TOTAL
	Skidtubes to be Strip with Stripper		
	SRP 14-12-S.		

Client: (PRINT NAME) _____ (SIGNATURE) _____

THANK YOU FOR YOUR BUSINESS!

New Parts used for Assembly of skid Tube.

Qty:	PART NO:	BATCH NO:
4x	AN3C-46A (bolts)	M130786
4x	AN3C-46A (bolts)	M131367
2x	AN3C-5A (bolts)	M131426
2x	MS24694-C52 (screw)	M127059
2x	NAS1149C033212 (washers)	M131340
16x	D3904-1 (washers)	M125626
8x	MS21043-3 (nuts)	M130673
2x	D2855-3 (discs)	B311898

15103109 (x1)